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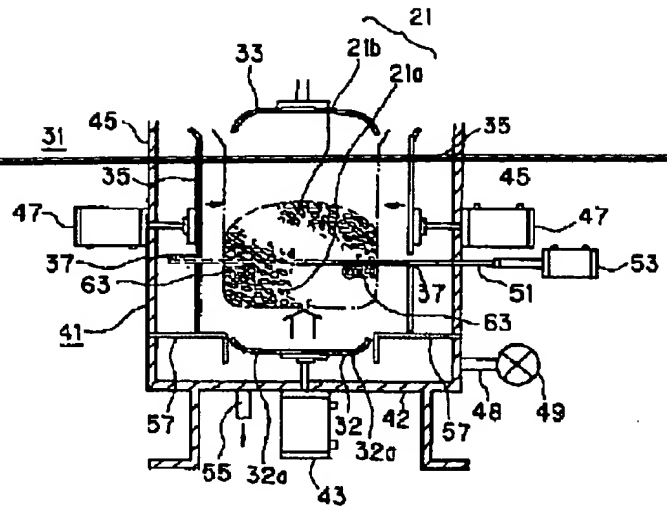
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TITLE : MANUFACTURE FOR PAD MATERIAL  
WITH DIFFERENT HARDNESS AND  
PRESS MOLDING DIE



ABSTRACT : PURPOSE: To improve working efficiency remarkably by eliminating classifying work and control of tip materials whose hardness is different from each other, and facilitating integration of a jointed surface of pad materials whose hardness is different and shortening molding time and drying time.

CONSTITUTION: A tip material is formed by crushing waste materials such as urethane with a crusher. The tip material is mixed with a hinder by means of a mixer, and a mixture 21 is molded by a press molding pattern 31. A partition wall 51 is installed onto the press molding pattern 31 so as to be taken out of and put in it. Mixtures 21a, 21b are inserted respectively in a small chamber formed by the partition wall 51, and the press molding die 31 is tightened. The partition wall 51 is then drawn out from the press molding die 31, and stream of water content necessary for reaction of the binder is supplied to reactively cure the binder.

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